



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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SWA6A-200
Job Sheet 196508



Part No: SWA6A-200

Job Qty: 10 pcs

Part Name: Upper End



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/13/19

Job Tracking No:

Due Date: 8/5/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG SWA6A-200 Rev8 IPP Rev A 17.11.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs	8/5/19	8/5/19	0.00	1.00	Bandsaw - 1		[Signature]
110	NLX 2500SY - B4B	10 pcs	8/5/19	8/5/19	1.00	10.00	NLX 2500SY - 1 - B4B		
120	QC 2	10 pcs	8/5/19	8/5/19	0.00	0.00	QC 2 - 1		[Signature]
							QC 2 - 12		
							QC 2 - 14		[Signature]
							QC 2 - 17		
							QC 2 - 19		[Signature]
							QC 2 - 2		
							QC 2 - 20		[Signature]
							QC 2 - 22		
							QC 2 - 23		[Signature]
							QC 2 - 25		
							QC 2 - 32		[Signature]
							QC 2 - 33		
							QC 2 - 35		[Signature]
							QC 2 - 39		
							QC 2 - 4		[Signature]
							QC 2 - 40		
							QC 2 - 44		[Signature]
							QC 2 - 45		
							QC 2 - 48		[Signature]
							QC 2 - 49		
							QC 2 - 50		[Signature]
							QC 2 - 51		
							QC 2 - 52		[Signature]
							QC 2 - 57		
							QC 2 - 62		[Signature]
							QC 2 - 63		
							QC 2 - 8		[Signature]
							QC 2 - 66		
							QC 2 - 64		[Signature]
							QC 2 - 65		
							QC 2 - 5		[Signature]
							QC 2 - 71		
							QC 2 - 73		[Signature]
							QC 2 - 69		
122	NV5000 - 1 - B4B	10 pcs	8/5/19	8/5/19	1.00	0.50	NV5000 - 1 - B4B		[Signature]
							NV5000 - 2 - B4B		
124	QC 2	10 pcs	8/5/19	8/5/19	0.00	0.00	QC 2 - 1		[Signature]
							QC 2 - 12		
							QC 2 - 14		[Signature]
							QC 2 - 17		



Container No: S190936



Part: SWA6A - 200

Job No: 196508

Serial No/Batch: S190936

Revision: 8

Inspector:

Exp Date:

Instructions:

Date: 06/17/19

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CANADA
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Plex 6/13/19 3:25 PM Dart.Renwick.Jennife

				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	32-11-19-06-20
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130	QC 8	10 pcs	8/5/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
140	Packaging 3-1 - Stock - B4B	10 pcs	8/5/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B

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					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150	QC 21 - SA	10 pcs	8/5/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut Blanks to 6.16"

Descriptions: 110 - NLX (MORI NLX 2500SY LATHE) 1-Machine as per DWG. FB705 FOLIO REV: AP DWG REV: 70

2-Deburr ***Machine engrave S/N number and machine engrave UP arrow***

120 - (QC2- Inspect parts off machine FAI/FAIB)

122 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) 1-Machine as per DWG. FB705 FOLIO REV: _____

DWG REV: _____ 2-Deburr

124 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Identify as per dwg & Stock Location: _____)

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R3.000	17-4 H1150 Round Bar 3.000"	5.1300 ft (.513 ea)	100-Bandsaw - 1	509/273

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-H1150-R3.000	5	8	0

Part Specifications

Specifications could not be found.

Plex 6/13/19 3:25 PM Dart.Renwick.Jennifer

DART AEROSPACE LTD		Work Order:	196-508
Description: UPPER END		Part Number:	
Inspection Dwg: SWA6A-200	Rev: B	Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.890	+0.015 / -0.000	.892	✓		gauge pin	
.04 x 45°	±.01 x .5°	.038 x 45°	✓		Vern LPI	
R.031	±.005	.031	✓		Rad gauge	
.04 x 45°	±.01 x .5°	.04 x 45°	✓		Vern LPI	
.07 x 45°	±.01 x .5°	.07 x 45°	✓		↓	
3-16 UN-2A						
Major 2.9936	±.0047	2.994	✓		Mic (Wt 31)	
Wire Ø.040						
DOW 3.0207	±.0028	3.018	✓		Mic 10-13	
1.030	±.005	1.034	✓		H-gauge	
6.038	±.005	6.036	✓		↓	
1.328	+0.000 / -0.005	1.3258	✓		Mic LPI	
Ø 2.320	±.005	2.320	✓		Vern LPI	
Ø 2.05	±.01	2.050	✓		↓	
R.220	±.005	0.219	✓		P.N Gauge	
.890	±.005	0.892	✓		caliper	ACL-08
1.14	+0.00 / -0.02	1.130	✓		Vern LPI	
R.13	±.01	.125	✓		Rad gauge	
10-32 UNF-2B	6-0 - N1060	O.K.	✓			
.25	±.01	0.280	✓			
.04 x 45°	±.01 x .5°	.04 x 45°	✓		Vern LPI	
Ø.500	±.005	.500	✓		Caliper	ACL-08
2.21	±.01	2.215	✓		H-gauge	
2.45	±.01	2.454	✓		↓	
2.94	±.01	2.935	✓		Caliper	ACL-08
.820	±.005	.821	✓		H-gauge	
.58 x 45°	±.01 x .5°	.58 x 45°	✓		Vern LPI	
R.13	±.01	.125	✓		rad. Gauge	
.07 x 45°	±.01 x .5°	.07 x 45°	✓		Vern LPI	

Measured by: P. J. 2016	Checked by: B. A.	QC Inspector:
Date: 19-06-21	Date: 19-07-14	Date:

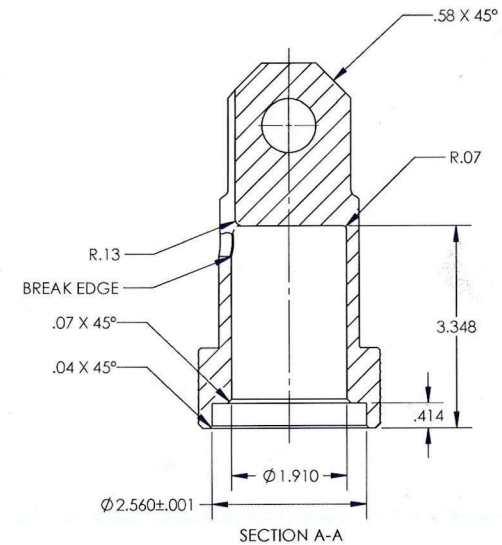
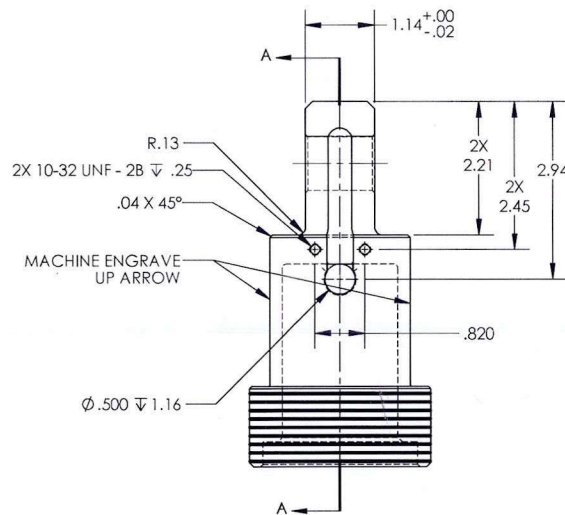
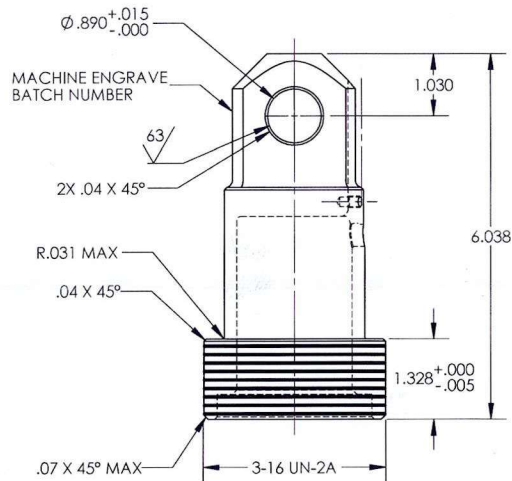
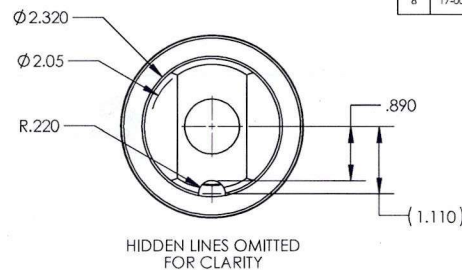
Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

2077

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		AS DRAWN BY CANAM.	11/4/2014	JAG	
5	14-0207	CHD CHAMFER ON Ø.890 HOLE WAS 2X .03 X 45° IS 2X .04 X 45°. CHD DIM WAS Ø2.06 IS Ø2.05.	11/4/2014	RJC	JAG
6	15-0092	ADDED MATERIAL H1075.	4/22/2015	RJC	JAG
7	15-0271	ADDED UP ARROW NOTE. CHD DIMS WAS 1.14 IS 1.14 +.00 -.02. WAS 2.21 IS 2X 2.21. DELETED DIMS Ø.90, Ø1.5/16, R.07. ADDED BREAK EDGE NOTE. CHD TOLERANCE ON NON-CRITICAL DIMENSIONS.	9/22/2015	DPD	JAG
8	17-0064	UPDATED TO NEW STANDARDS. CHD DIM WAS R.07 IS R.13. WAS 2X 10-32 UNF .25 IS 2X 10-32 UNF .28 .25. ADDED NOTE MACHINE ENGRAVE BATCH NUMBER.	3/17/2017	SM	JAG



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA6A-200	1	UPPER END	SS 17-4, H1150, H1075	

DART AEROSPACE	
TITLE UPPER END	
DWG NO. SWA6A-200	REV 8
MATL: SS 17-4, H1150, H1075	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT FINISH	.XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES ± 125
SPEC	1. BREAK ALL SHARP EDGES Ø15 X 45° OR Ø15R
DRAWN BY: CANAM	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DD 03/17/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 03/20/2017	USED ON MODEL
QA APPR: JL 03/29/2017	
APPROVED: JAG 04/03/2017	
SCALE 1:2	DATE 1/31/2002 SHEET 1 OF 1